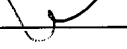


Date: Friday, 05/09/2008 7:13:20 AM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: FLOOR PROCTOR FWD LH
Job Number	: 41849		
Estimate Number	: 11227		
P.O. Number	:	Part Number	: D32811
This Issue	: 05/09/2008 S.O. No. :	Drawing Number	: D3281 REV D
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: // Type : THERMOFORMING	Drawing Revision	: D
Previous Run	: 40472	Material	:
Written By	: 	Due Date	: 12/09/2008
Checked & Approved By	:	Qty:	<u>3</u> Um: Each
Comment	: Est Rev.A 04.07.01 New issue KJ/JLM : Est. Rev B. 07.16.2007 Thermoform in house DL : Est Rev C. 08.02.06 To reflect updated Dwg. DL : Est Rev. D 08.04.15 Material Change DL		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	MLEXS093F600602	GE PLASTICS LEXAN SHEET
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Comment: Qty.: 4.3330 sf(s)/Unit Total : 21.6650 sf(s)
 GE PLASTICS LEXAN SHEET

Material Batch Number M106751

2.0	HAND FINISH TH	HAND FINISHING THERMOFORMING
-----	----------------	------------------------------



Comment: HAND FINISHING THERMOFORMING

1) Cut Blanks

BB 08/09/05 X3

3.0	THERMOFORMING	THERMOFORMING MACHINE
-----	---------------	-----------------------



Comment: THERMOFORMING MACHINE

Thermoform as per Dwg. D32811 and Folio FTA 011

Dwg. Rev. DFolio Rev. B

BB 08/09/08/X3

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

BB 08/09/08/X3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 05/09/2008 7:13:20 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOOR PROCTOR FWD LH

Job Number: 41849

Part Number: D32811

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

HAND FINISH TH

HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

1) Trim to Finished Dimensions

BB 08/09/09 (X3)

6.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

1) Check Surface finish for undesired marks, voids, dimples etc.

2) Check dimensions to ensure conformity to drawing tolerances.

BB 08/09/09 (X3)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/09/09 (43)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

ST273

BS 08/09/10 (3)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/09/10 (4)

Job Completion



mf 08-09-10

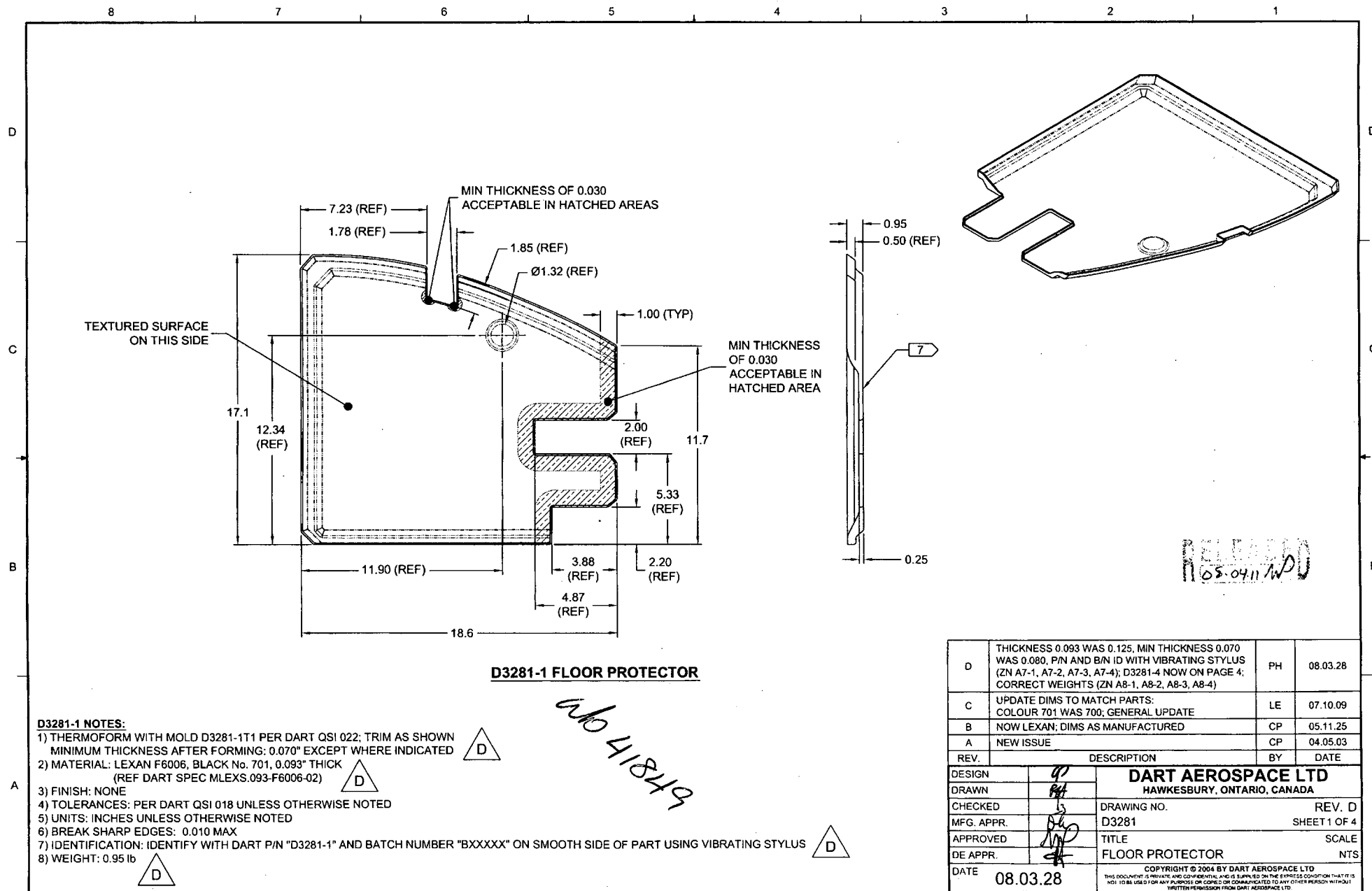
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DART AEROSPACE LTD		Work Order:	41849
Description: Floor Protector, Fwd LH		Part Number:	D3281-1
Inspection Dwg: D3281	Rev: D	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than 0.1875" Go/No Go	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: <i>BS</i>	Date: 08/09/08
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TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
18.6	+/-0.100	18.625	✓			
17.1	+/-0.100	17.125	✓			
11.7	+/-0.100					
0.95	+/-0.030	.950	✓			
0.25	+/-0.030	.250	✓			
0.030	Min	.56	✓			
0.070	+/-0.040 min	.0805	✓			

Measured by: <i>BS</i>	Date: 08/09/08
Audited by: <i>CS</i>	Date: 08/09/08
Prototype Approval: N/A	Date: N/A

Rev	Date	Change	Revised by	Approved
A	08.02.28	New Issue	KJ/DL	
B	08.04.16	Dimensions updated per Dwg Rev D	KJ/DL <i>JA</i>	<i>BE</i>

JA

DART AEROSPACE LTD		Work Order:	41849
Description: Floor Protector, Fwd LH		Part Number:	D3281-1
Inspection Dwg: D3281	Rev: D	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than 0.1875" Go/No Go	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: BD Date: 08/09/09

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
18.6	+/-0.100	18.55	✓			
17.1	+/-0.100	17.125	✓			
11.7	+/-0.100	11.65	✓			
0.95	+/-0.030	.978	✓			
0.25	+/-0.030	.264	✓			
0.030	Min	.060	✓			
0.070	+/-0.010	.072	✓			
	MW					

Measured by: BD Date: 08/09/09
Audited by: O Date: 8/9/9
Prototype Approval: N/A Date: N/A

Rev	Date	Change	Revised by	Approved
A	08.02.28	New Issue	KJ/DL	
B	08.04.16	Dimensions updated per Dwg Rev D	KJ/DL	

DART AEROSPACE LTD		Work Order: 41849
Description: Floor Protector, Fwd LH		Part Number: D3281-1
Inspection Dwg: D3281	Rev: D	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than 0.1875" Go/No Go	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: JB

Date: 08/09/09

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
18.6	+/-0.100	18.625	✓			
17.1	+/-0.100	17.125	✓			
11.7	+/-0.100					
0.95	+/-0.030	.971	✓			
0.25	+/-0.030	.254	✓			
0.030	Min	.063	✓			
0.070	+/-0.010	.0795	✓			
	M12					

Measured by: JB

Date: 08/09/09

Audited by: S

Date: 08/10/09

Prototype Approval: N/A

Date: N/A

Rev	Date	Change	Revised by	Approved
A	08.02.28	New Issue	KJ/DL	
B	08.04.16	Dimensions updated per Dwg Rev D	KJ/DL	